

Work Order ID 69326

Monday, May 09, 2011 9:18:22 AM

Page 1

Item ID: D3196-1

Accept

Revision ID:

Item Name: Bar

Start Date: 5/9/2011

Start Qty: 2.00

Required Date: 5/12/2011

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-05-09*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3196

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: (0.75" x 1.50") x 26.200" long Bar

*JW 11-05-10**4**Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3196-1 as per Folio FA339 and Dwg D31961 Identify as D3196-1 □2-
Deburr*JW 11-05-10**4**Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*JW**11-05-10**4**Ø*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69326

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Item ID: D3196-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

21 11.5. 8/10



QC

Memo

0.00

Quality Control

4

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 0 M-1 11/05/10

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

FINISH TIME:

OVEN TEMPERATURE:

2:45

3200

3:15

4 0 M-1 11/05/11

M115128

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 69326

Page 3

Monday, May 09, 2011 9:18:22 AM

Item ID: D3196-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

4

11-5-12

170



Identify as per dwg & Stock Location: 260

0.00

Packaging

Memo

0.00

Packaging

11/5/12 (4)

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/5/12
MF
11-05-12

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, May 09, 2011 9:18:20 AM

Work Order ID: 69326

Parent Item: D3196-1

Parent Item Name: Bar



Start Date: 5/9/2011

Required Date: 5/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	30.7417	2.183	4.595789			



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT003

30.7417

116405

9.9997

116604

1.5

116623

19.242

8.7564 JLM 05.11.11

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

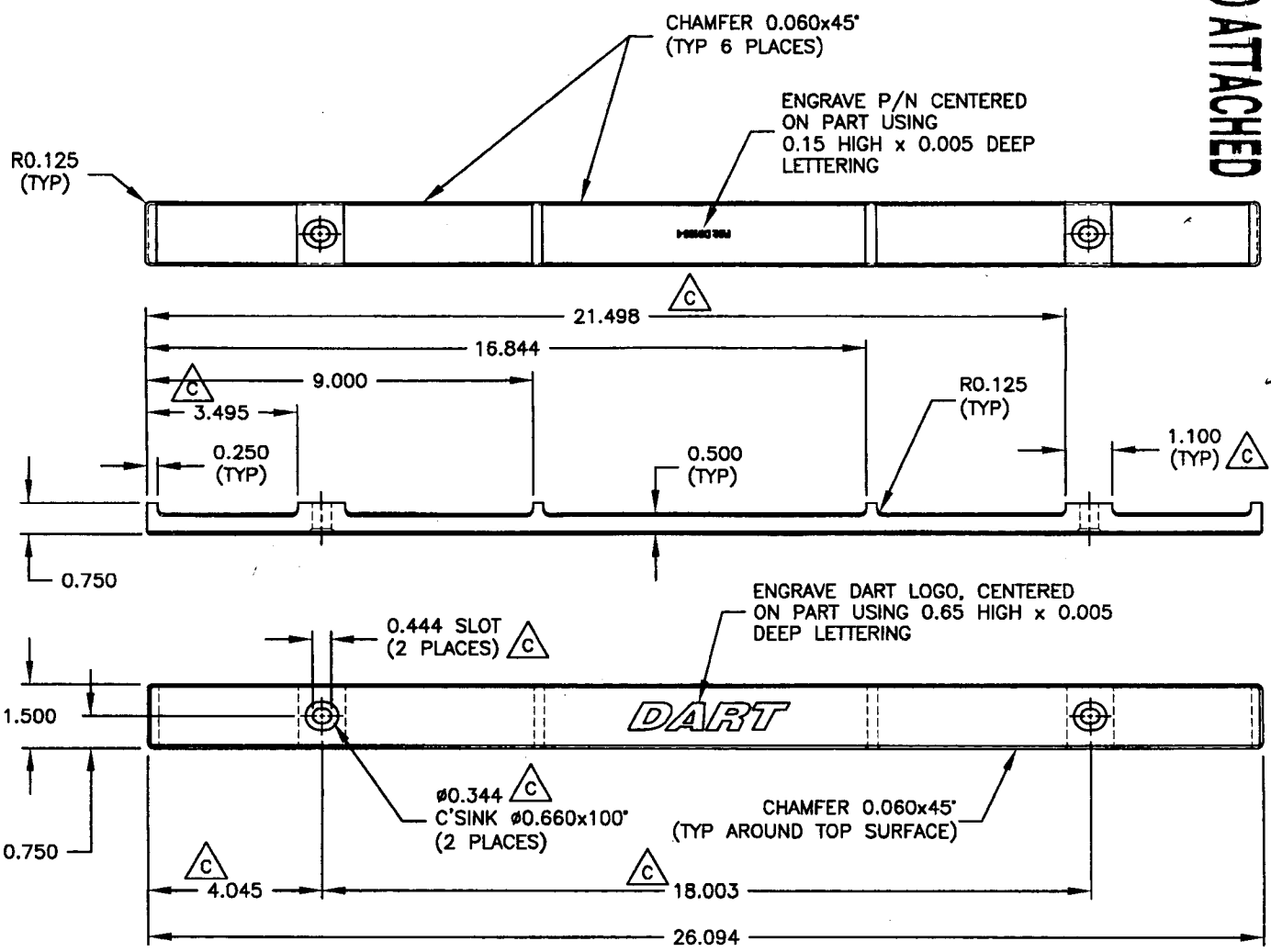


RELEASED

06.10.31

#69326

DEO ATTACHED



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	Q	DRAWN BY	DART AEROSPACE LTD
CHECKED	PH	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	TITLE	BAR
REV.	A	03.06.25	NEW ISSUE
B	06.09.25	ADD D3196-5	
C	06.10.31	ADD SLOTS ON -1; REMOVED -5	
SCALE	1:4		

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3196-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04		

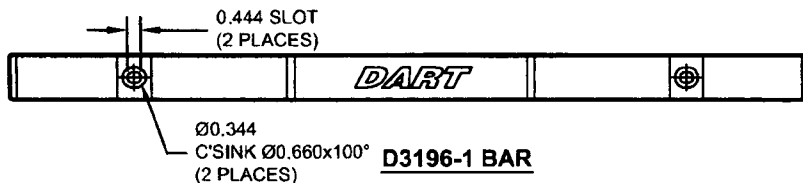
SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN:

IS:



D3196-1 BAR

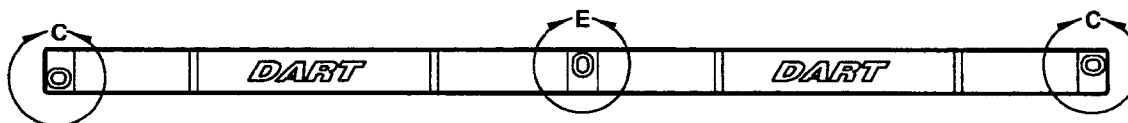
WAS:



D3196-1 BAR

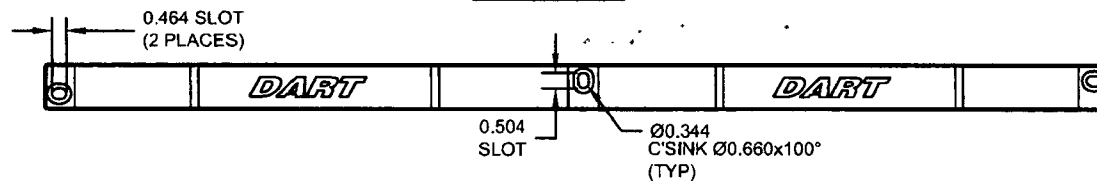
SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN:

IS:



D3196-3 BAR

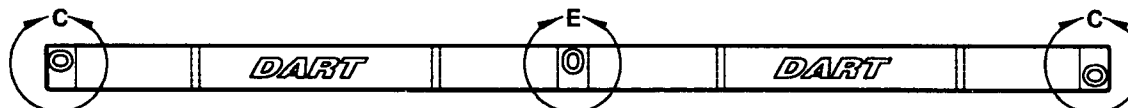
WAS:



D3196-3 BAR

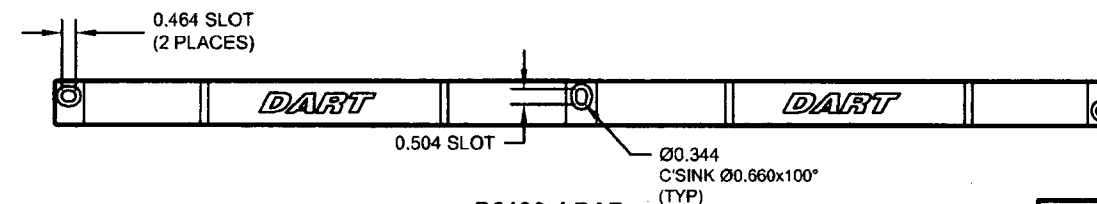
SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN:

IS:



D3196-4 BAR

WAS:



D3196-4 BAR

#69326

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69326
Description: Bar		Part Number:	D3196-1
Inspection Dwg: D3196	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.094	-		Tape	
4.045	+/-0.010	4.045	-		JMVB	
18.003	+/-0.005	18.00	-		Tape	
0.750	+/-0.005	0.748	✓		JMVB	
1.500	+/-0.010	1.501	✓		" "	
Ø0.344	+0.006/-0.001	Ø.343	✓		JMVB	
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø.660	✓		JMVB	
0.060 x 45°	+/-0.010 x 0.5°	0.070 x 45	✓		JMVB	
0.750	+/-0.010	0.748	✓		" "	
0.250	+/-0.010	0.254	✓		" "	
3.495	+/-0.010	3.499	✓		" "	
9.000	+/-0.010	9.00	✓		CNC-02	
16.844	+/-0.010	16.842	✓		" "	
21.498	+/-0.010	21.507	✓		" "	
R0.125	+/-0.010	R.125	✓		R-6	
1.100	+/-0.010	1.091	✓		JMVB	
R0.125	+/-0.010	R.125	✓		R-6	
0.444	+/-0.010	0.444	✓		JMVB	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	11-05-10	Date:	11-5-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	
C	07.03.21	Dimensions updated per Dwg rev. C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>